



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D3391-023**  
**Job Sheet 193564**



Part No: D3391-023

Job Qty: 1 pcs

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *STU*Description: *orden 15313*

Note: DWG REV J SHEET 2 and 7 IPP A 05.10.20 New Issue KJ/EC IPP B IPP C 07.03.20 rev F dwg EC IPP D 07.03.28 re-format EC IPP E 07.10.31 ecn 1053P EC IPP Rev:F ECN 1056 07-11-13 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec IPP Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier      |           | Sign-off  |
|-------|-------------------------------|-------|------------|----------|-----------|---------|--------------------------|-----------|-----------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier    | Lead Time |           |
| 90    | Start up Operation            | 1 Ea  | 4/26/19    | 4/26/19  | 0.00      | 0.00    | Start Up Skidtubes-1     |           | <i>mb</i> |
| 100   | Skidtubes - 1                 | 1 pcs | 4/26/19    | 4/26/19  | 0.00      | 2.11    | Skidtubes - 1            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 2            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 3            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 4            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 5            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 6            |           |           |
|       |                               |       |            |          |           |         | Skidtubes - 7            |           |           |
| 110   | QC 5                          | 1 pcs | 4/26/19    | 4/26/19  | 0.00      | 0.00    | QC 5 - 10                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 12                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 17                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 18                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 19                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 22                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 24                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 3                 |           |           |
|       |                               |       |            |          |           |         | QC 5 - 43                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 49                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 51                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 58                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 68                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 9                 |           |           |
|       |                               |       |            |          |           |         | QC 5 - 50                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 30                |           |           |
|       |                               |       |            |          |           |         | QC 5 - 40                |           |           |
| 120   | Handfinish - 1-1 Chemical-B4B | 1 pcs | 4/26/19    | 4/26/19  | 0.00      | 0.38    | Handfinish - 1 - 1 - B4B |           |           |
|       |                               |       |            |          |           |         | Handfinish - 1 - 2 - B4B |           |           |
|       |                               |       |            |          |           |         | Handfinish - 1 - 3 - B4B |           |           |

Plex 4/16/19 1:49 PM Dart.lajeunesse.marie



Container No: S175269



Part: D3391-023

Job No: 193564

Serial No/Batch: S175269

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 04/25/19

DAS  
24  
9-89

MAY 30 2019



|                         |          |         |           |  |                           |     |
|-------------------------|----------|---------|-----------|--|---------------------------|-----|
|                         |          |         |           |  | Handfinish - 1 - 4 - B4B  |     |
|                         |          |         |           |  | Handfinish - 1 - 5 - B4B  | 1-5 |
|                         |          |         |           |  | Handfinish - 1 - 6 - B4B  |     |
|                         |          |         |           |  | Handfinish - 1 - 7 - B4B  |     |
|                         |          |         |           |  | Handfinish - 1 - 8 - B4B  |     |
|                         |          |         |           |  | Handfinish - 1 - 9 - B4B  |     |
|                         |          |         |           |  | Handfinish - 1 - 10 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 11 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 12 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 13 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 14 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 15 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 16 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 17 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 18 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 19 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 20 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 21 - B4B |     |
|                         |          |         |           |  | Handfinish - 1 - 22 - B4B |     |
| 130 QC 7                | 1<br>pcs | 4/26/19 | 0.00 0.00 |  | QC 7 - 10                 |     |
|                         |          |         |           |  | QC 7 - 13                 |     |
|                         |          |         |           |  | QC 7 - 14                 |     |
|                         |          |         |           |  | QC 7 - 15                 |     |
|                         |          |         |           |  | QC 7 - 17                 |     |
|                         |          |         |           |  | QC 7 - 18                 |     |
|                         |          |         |           |  | QC 7 - 19                 |     |
|                         |          |         |           |  | QC 7 - 2                  |     |
|                         |          |         |           |  | QC 7 - 28                 |     |
|                         |          |         |           |  | QC 7 - 3                  |     |
|                         |          |         |           |  | QC 7 - 30                 |     |
|                         |          |         |           |  | QC 7 - 34                 |     |
|                         |          |         |           |  | QC 7 - 36                 |     |
|                         |          |         |           |  | QC 7 - 37                 |     |
|                         |          |         |           |  | QC 7 - 41                 |     |
|                         |          |         |           |  | QC 7 - 47                 |     |
|                         |          |         |           |  | QC 7 - 48                 |     |
|                         |          |         |           |  | QC 7 - 51                 |     |
|                         |          |         |           |  | QC 7 - 58                 |     |
|                         |          |         |           |  | QC 7 - 59                 |     |
|                         |          |         |           |  | QC 7 - 60                 | MBB |
|                         |          |         |           |  | QC 7 - 9                  |     |
|                         |          |         |           |  | QC 7 - 68                 |     |
|                         |          |         |           |  | QC 7 - 50                 |     |
|                         |          |         |           |  | QC 7 - 67                 |     |
|                         |          |         |           |  | QC 7 - 40                 |     |
| 140 Skidtubes - 2 - B4B | 1<br>pcs | 4/26/19 | 0.00 2.11 |  | Skidtubes - 1 - B4B       |     |
|                         |          |         |           |  | Skidtubes - 2 - B4B       |     |
|                         |          |         |           |  | Skidtubes - 3 - B4B       | mbk |

|                                   |          |         |           |  |                          |                         |
|-----------------------------------|----------|---------|-----------|--|--------------------------|-------------------------|
|                                   |          |         |           |  | Skidtubes - 4 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 5 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 6 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 7 - B4B      |                         |
| 150 QC 5                          | 1<br>pcs | 4/26/19 | 0.00 0.00 |  | QC 5 - 10                |                         |
|                                   |          |         |           |  | QC 5 - 12                |                         |
|                                   |          |         |           |  | QC 5 - 17                |                         |
|                                   |          |         |           |  | QC 5 - 18                | BE                      |
|                                   |          |         |           |  | QC 5 - 19                |                         |
|                                   |          |         |           |  | QC 5 - 22                |                         |
|                                   |          |         |           |  | QC 5 - 24                |                         |
|                                   |          |         |           |  | QC 5 - 3                 |                         |
|                                   |          |         |           |  | QC 5 - 43                |                         |
|                                   |          |         |           |  | QC 5 - 49                |                         |
|                                   |          |         |           |  | QC 5 - 51                |                         |
|                                   |          |         |           |  | QC 5 - 58                |                         |
|                                   |          |         |           |  | QC 5 - 68                |                         |
|                                   |          |         |           |  | QC 5 - 9                 |                         |
|                                   |          |         |           |  | QC 5 - 50                |                         |
|                                   |          |         |           |  | QC 5 - 30                |                         |
|                                   |          |         |           |  | QC 5 - 40                |                         |
| 160 Skidtubes - 3 - B4B           | 1<br>pcs | 4/26/19 | 0.00 2.11 |  | Skidtubes - 1 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 2 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 3 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 4 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 5 - B4B      | BE                      |
|                                   |          |         |           |  | Skidtubes - 6 - B4B      |                         |
|                                   |          |         |           |  | Skidtubes - 7 - B4B      |                         |
| 170 QC 10                         | 1<br>pcs | 4/26/19 | 0.00 0.00 |  | QC 10 - 10               |                         |
|                                   |          |         |           |  | QC 10 - 18               |                         |
|                                   |          |         |           |  | QC 10 - 24               | DAS 24 9-89 JUN 05 2019 |
|                                   |          |         |           |  | QC 10 - 43               |                         |
|                                   |          |         |           |  | QC 10 - 50               |                         |
|                                   |          |         |           |  | QC 10 - 58               |                         |
|                                   |          |         |           |  | QC 10 - 9                |                         |
| 180 QC 5                          | 1<br>pcs | 4/26/19 | 0.00 0.00 |  | QC 5 - 10                |                         |
|                                   |          |         |           |  | QC 5 - 12                |                         |
|                                   |          |         |           |  | QC 5 - 17                |                         |
|                                   |          |         |           |  | QC 5 - 18                |                         |
|                                   |          |         |           |  | QC 5 - 19                |                         |
|                                   |          |         |           |  | QC 5 - 22                |                         |
|                                   |          |         |           |  | QC 5 - 24                | DAS 24 9-89 JUN 05 2019 |
|                                   |          |         |           |  | QC 5 - 3                 |                         |
|                                   |          |         |           |  | QC 5 - 43                |                         |
|                                   |          |         |           |  | QC 5 - 49                |                         |
|                                   |          |         |           |  | QC 5 - 51                |                         |
|                                   |          |         |           |  | QC 5 - 58                |                         |
|                                   |          |         |           |  | QC 5 - 68                |                         |
|                                   |          |         |           |  | QC 5 - 9                 |                         |
|                                   |          |         |           |  | QC 5 - 50                |                         |
|                                   |          |         |           |  | QC 5 - 30                |                         |
|                                   |          |         |           |  | QC 5 - 40                |                         |
| 185 Handfinish - 2-1 Pressure-B4B | 1<br>pcs | 4/26/19 | 0.00 0.00 |  | Handfinish - 2 - 1 - B4B | JUN 04 2019             |
|                                   |          |         |           |  | Handfinish - 2 - 2 - B4B |                         |
|                                   |          |         |           |  | Handfinish - 2 - 3 - B4B |                         |
|                                   |          |         |           |  | Handfinish - 2 - 4 - B4B |                         |
| 191 Spray Paint - 2 - B4B         | 1<br>pcs | 4/26/19 | 0.00 0.91 |  | Spray Paint - 1 - B4B    | AS 17-6-6               |
|                                   |          |         |           |  | Spray Paint - 2 - B4B    |                         |
|                                   |          |         |           |  | Spray Paint - 3 - B4B    |                         |



|                                   |          |         |                       |                           |           |
|-----------------------------------|----------|---------|-----------------------|---------------------------|-----------|
|                                   |          |         | Spray Paint - 4 - B4B |                           |           |
| 192 Outsource - 11 - Paint        | 1<br>pcs | 4/26/19 |                       | ATE003-VC                 |           |
| 193 Packaging 2-1 - Receive - B4B | 1<br>pcs | 4/26/19 | 0.00 0.00             | Packaging 2 - 1 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 2 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 3 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 5 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 4 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 6 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 7 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 8 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 9 - B4B     |           |
|                                   |          |         |                       | Packaging 2 - 10 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 11 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 12 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 13 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 14 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 15 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 16 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 17 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 18 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 19 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 20 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 21 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 22 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 23 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 24 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 25 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 26 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 27 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 28 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 29 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 30 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 31 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 32 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 33 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 34 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 35 - B4B    |           |
|                                   |          |         |                       | Packaging 2 - 36 - B4B    |           |
| 200 QC 14                         | 1<br>pcs | 4/26/19 | 0.00 0.00             | QC 14 - 15                | HL 19-6-7 |
|                                   |          |         |                       | QC 14 - 2                 |           |
|                                   |          |         |                       | QC 14 - 34                |           |
|                                   |          |         |                       | QC 14 - 41                |           |
|                                   |          |         |                       | QC 14 - 51                |           |
|                                   |          |         |                       | QC 14 - 58                |           |
|                                   |          |         |                       | QC 14 - 59                |           |
|                                   |          |         |                       | QC 14 - 9                 |           |
|                                   |          |         |                       | QC 14 - 68                |           |
|                                   |          |         |                       | QC 14 - 40                |           |
|                                   |          |         |                       | QC 14 - 19                |           |
| 230 Handfinish - 4-1-Assembly-B4B | 1<br>pcs | 4/26/19 | 0.00 0.38             | Handfinish - 4 - 1 - B4B  | HL 19-6-7 |
|                                   |          |         |                       | Handfinish - 4 - 10 - B4B |           |
|                                   |          |         |                       | Handfinish - 4 - 11 - B4B |           |
|                                   |          |         |                       | Handfinish - 4 - 12 - B4B |           |
|                                   |          |         |                       | Handfinish - 4 - 13 - B4B |           |
|                                   |          |         |                       | Handfinish - 4 - 14 -     |           |

Plex 4/16/19 1:49 PM Dart.lajeunesse.marie



|                                 |     |         |           |                           |  |
|---------------------------------|-----|---------|-----------|---------------------------|--|
|                                 |     |         |           | B4B                       |  |
|                                 |     |         |           | Handfinish - 4 - 15 - B4B |  |
|                                 |     |         |           | Handfinish - 4 - 2 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 3 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 4 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 5 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 6 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 7 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 8 - B4B  |  |
|                                 |     |         |           | Handfinish - 4 - 9 - B4B  |  |
| 240 QC 5                        | 1   | 4/26/19 | 0.00 0.00 | QC 5 - 10                 |  |
|                                 | pcs |         |           | QC 5 - 12                 |  |
|                                 |     |         |           | QC 5 - 17                 |  |
|                                 |     |         |           | QC 5 - 18                 |  |
|                                 |     |         |           | QC 5 - 19                 |  |
|                                 |     |         |           | QC 5 - 22                 |  |
|                                 |     |         |           | QC 5 - 24                 |  |
|                                 |     |         |           | QC 5 - 3                  |  |
|                                 |     |         |           | QC 5 - 43                 |  |
|                                 |     |         |           | QC 5 - 49                 |  |
|                                 |     |         |           | QC 5 - 51                 |  |
|                                 |     |         |           | QC 5 - 58                 |  |
|                                 |     |         |           | QC 5 - 68                 |  |
|                                 |     |         |           | QC 5 - 9                  |  |
|                                 |     |         |           | QC 5 - 50                 |  |
|                                 |     |         |           | QC 5 - 30                 |  |
|                                 |     |         |           | QC 5 - 40                 |  |
| 250 Packaging 3-1 - Stock - B4B | 1   | 4/26/19 | 0.00 0.00 | Packaging 3 - 1 - B4B     |  |
|                                 | pcs |         |           | Packaging 3 - 2 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 3 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 4 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 5 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 6 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 7 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 8 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 9 - B4B     |  |
|                                 |     |         |           | Packaging 3 - 10 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 11 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 12 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 13 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 14 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 15 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 16 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 17 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 18 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 19 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 20 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 21 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 22 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 23 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 24 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 25 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 26 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 27 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 28 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 29 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 30 - B4B    |  |
|                                 |     |         |           | Packaging 3 - 31 - B4B    |  |

DAS  
40  
9-89

JUN 07 2019

DAS  
58  
9-89

JUN 10 2019

|                |     |         |           |                        |  |
|----------------|-----|---------|-----------|------------------------|--|
|                |     |         |           | Packaging 3 - 32 - B4B |  |
|                |     |         |           | Packaging 3 - 33 - B4B |  |
|                |     |         |           | Packaging 3 - 34 - B4B |  |
|                |     |         |           | Packaging 3 - 35 - B4B |  |
|                |     |         |           | Packaging 3 - 36 - B4B |  |
| 260 QC 21 - SA | 1   | 4/26/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                | pcs |         |           | QC 21 - SA - 70        |  |
|                |     |         |           | QC 21 - SA - 53        |  |

Part Op 100 - Skid tubes - 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and Descriptions: drill only 1 fwd saddle hole on one side only as per Dwg D3391 3-Open aft saddles and GHW holes to Ø0.4375" except for fwd saddle holes 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skid tube as per Dwg D3391 6-Deburr, scribe batch # on aft end. 7-Locate D3391-021 in D3391-023 at 9.00" (see view F-F) 8- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect alignment, open up previously transfer drilled pilot holes in D3391-023/-021 using drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". D3391-021 BATCH: N/A 9- Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.375" holes with paint marker, \*\*\*DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG\*\*\* Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplate holes in D3391-021 using DT8937 10- Open wearplate holes of D3391-023 assembly detail section Q-Q to Ø0.375" (10 holes) as per Dwg D3391 Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 Deburr and blow out all chips from inside

110 - QC5- Inspect part completeness to step on W/O  
 120 - Chemical Conversion Coat per QSI005 4.1  
 130 - QC7-Inspect Chemical Conversion Coat  
 140 - Skid tubes - 1-Open float bag holes as per dwg 2-C/sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours) A/R Sikaflex exp: 19-12-08 batch#: 5174347 NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE  
 150 - QC5- Inspect part completeness to step on W/O  
 160 - Skid tubes - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush 4/2 139011  
 170 - QC10- Inspect visual per QSI004- ground welds  
 180 - QC5- Inspect part completeness to step on W/O  
 185 - Pressure Wash per QSI005 4.3/ Clean and remove all marking - Re-alodine  
 191 - Spray Paint / NDT Room - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5179552  
 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 5188315  
 193 - Receive & Inspect for Damage & Mat'l Certs  
 200 - QC14- Inspect Spray Paint  
 230 - Assemble as per dwg - 1-Install Inserts as per Dwg  
 240 - QC5- Inspect part completeness to step on W/O  
 250 - Identify as per dwg & Stock Location:  
 260 - QC21- Final Inspection - Work Order Release

## Job BOM

| Part / Item   | Component Name      | Quantity      | Operation                         |
|---------------|---------------------|---------------|-----------------------------------|
| D2500-1-100   | Skid tube Extrusion | 1 pcs (1 ea)  | 90-Start up Operation             |
| D3389-1       | Web                 | 1 pcs (1 ea)  | 140-Skid tubes - 2 - B4B          |
| D3681-1       | Spacer              | 5 pcs (5 ea)  | 160-Skid tubes - 3 - B4B          |
| ALS4-1032-130 | Rivnut              | 20 Ea (20 ea) | 230-Handfinish - 4-1-Assembly-B4B |
| D3591-1       | Bushing             | 2 pcs (2 ea)  | 230-Handfinish - 4-1-Assembly-B4B |

010228  
 Container  
 B163253  
 S117267  
 S145873  
 S057267  
 S122431

## Job Allocations

| Operation                         | Component Part | Required | Inventory | Allocated |
|-----------------------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation             | D2500-1-100    | 1        | 116       | 0         |
| 140-Skid tubes - 2 - B4B          | D3389-1        | 1        | 9         | 0         |
| 160-Skid tubes - 3 - B4B          | D3681-1        | 5        | 156       | 0         |
| 230-Handfinish - 4-1-Assembly-B4B | ALS4-1032-130  | 20       | 8,655     | 0         |
|                                   | D3591-1        | 2        | 29        | 0         |

## Part Specifications

Specifications could not be found.



# D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

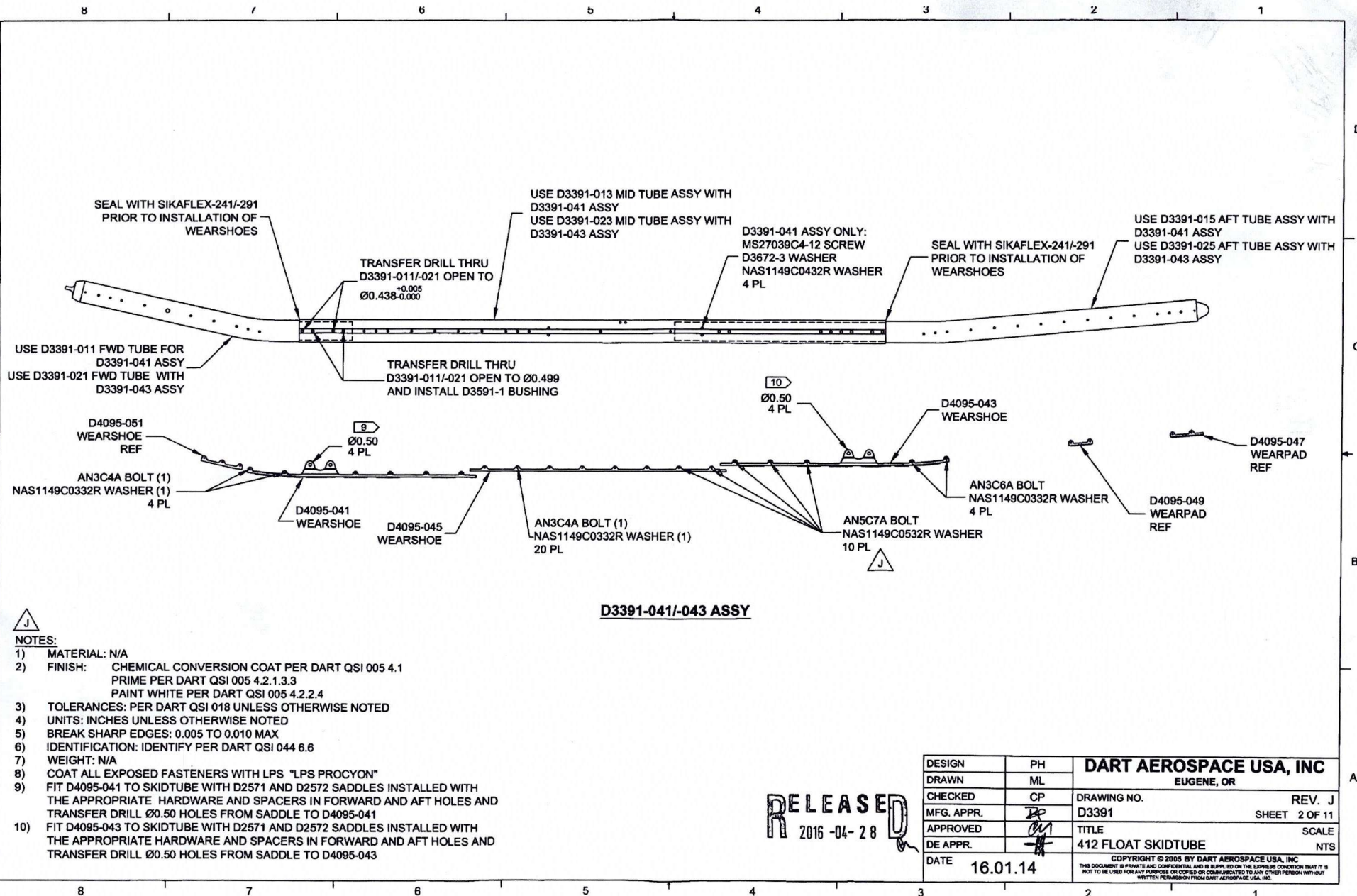
| QTY<br>-041 | QTY<br>-043 | PART NUMBER   | DESCRIPTION             |
|-------------|-------------|---------------|-------------------------|
| X           | X           | D3391-041     | FLOAT SKIDTUBE ASSEMBLY |
|             |             | D3391-043     | FLOAT SKIDTUBE ASSEMBLY |
| 1           |             | D3391-011     | FWD TUBE ASSEMBLY       |
| 1           |             | D3391-013     | MID TUBE ASSEMBLY       |
| 1           |             | D3391-015     | AFT TUBE ASSEMBLY       |
|             | 1           | D3391-021     | FWD TUBE ASSEMBLY       |
|             | 1           | D3391-023     | MID TUBE ASSEMBLY       |
|             | 1           | D3391-025     | AFT TUBE ASSEMBLY       |
| 2           | 2           | D3591-1       | BUSHING                 |
| 4           |             | D3672-3       | WASHER                  |
| 1           | 1           | D4095-041     | WEARSHOE                |
| 1           | 1           | D4095-043     | WEARSHOE                |
| 1           | 1           | D4095-045     | WEARSHOE                |
| 1           | 1           | D4095-047     | WEARPAD                 |
| 1           | 1           | D4095-049     | WEARPAD                 |
| 1           | 1           | D4095-051     | WEARSHOE                |
| 24          | 24          | AN3C4A        | BOLT                    |
| 4           | 4           | AN3C6A        | BOLT                    |
| 10          | 10          | AN5C7A        | BOLT                    |
| 28          | 28          | NAS1149C0332R | WASHER                  |
| 10          | 10          | NAS1149C0532R | WASHER                  |
| 4           |             | MS27039C4-12  | SCREW                   |
| 4           |             | NAS1149C0432R | WASHER                  |

J

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 193564 MWS  
1904-16

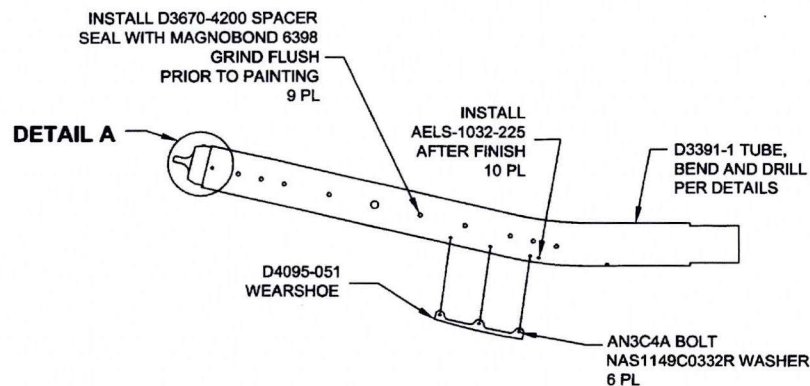
|            |                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                                          |               |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| J          | INCORPORATED DSI 9733, REFORMAT DRAWING<br>CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED<br>TABLES, REPLACED POWDER COAT WITH PAINT                                                                                                                                                                  | ML                                                                                                                                                                                                                                                                                       | 16.01.14      |
| I          | REMOVE GASKETS AND REPLACE ALL WEARSHOES;<br>PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4,<br>ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2,<br>ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130,<br>ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4<br>ZN D2-4, ZN D7-8, ZN D3-8                      | XDF                                                                                                                                                                                                                                                                                      | 11.10.13      |
| H          | DRAWING UPDATED TO CURRENT STANDARDS.<br>SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM<br>WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING.<br>SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM<br>WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING.<br>(FOR FURTHER INFO SEE DSI 9384 & NCR 08-074) | AJS                                                                                                                                                                                                                                                                                      | 08.08.20      |
| G          | REPLACE NAS INSERTS W/ AELS INSERTS<br>SWITCH TO D3670-XXXX SPACERS FOR INSTALLING<br>FLOAT BAGS, DWG REORGANIZED FOR CLARITY                                                                                                                                                                       | DC                                                                                                                                                                                                                                                                                       | 07.07.31      |
| F          | ADD SS WEARSHOE, GASKET<br>REMOVE FWD SADDLE HOLE -011/-021                                                                                                                                                                                                                                         | PH                                                                                                                                                                                                                                                                                       | 07.01.18      |
| E          | CHANGE TOLERANCE, EASE MANUFACTURE                                                                                                                                                                                                                                                                  | PH                                                                                                                                                                                                                                                                                       | 06.04.25      |
| D          | UPDATE TOLERANCE, CHANGE HOLE SIZE                                                                                                                                                                                                                                                                  | PH                                                                                                                                                                                                                                                                                       | 06.01.23      |
| C          | LENGTHEN AFT EXTENSION                                                                                                                                                                                                                                                                              | PH                                                                                                                                                                                                                                                                                       | 05.09.27      |
| B          | DRAWING UPDATES                                                                                                                                                                                                                                                                                     | PH                                                                                                                                                                                                                                                                                       | 05.06.10      |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                                           | PH                                                                                                                                                                                                                                                                                       | 05.02.07      |
| REV        | DESCRIPTION                                                                                                                                                                                                                                                                                         | BY                                                                                                                                                                                                                                                                                       | DATE          |
| DESIGN     | PH                                                                                                                                                                                                                                                                                                  | DART AEROSPACE USA, INC                                                                                                                                                                                                                                                                  |               |
| DRAWN      | ML                                                                                                                                                                                                                                                                                                  | EUGENE, OR                                                                                                                                                                                                                                                                               |               |
| CHECKED    | CP                                                                                                                                                                                                                                                                                                  | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. J        |
| MFG. APPR. | CP                                                                                                                                                                                                                                                                                                  | D3391                                                                                                                                                                                                                                                                                    | SHEET 1 OF 11 |
| APPROVED   | CP                                                                                                                                                                                                                                                                                                  | TITLE                                                                                                                                                                                                                                                                                    | SCALE         |
| DE APPR.   | CP                                                                                                                                                                                                                                                                                                  | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                       | NTS           |
| DATE       | 16.01.14                                                                                                                                                                                                                                                                                            | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |               |

RELEASED  
2016-04-28  
ECN 16-516

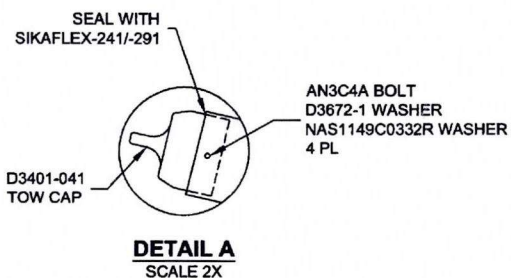


RELEASED  
 2016-04-28





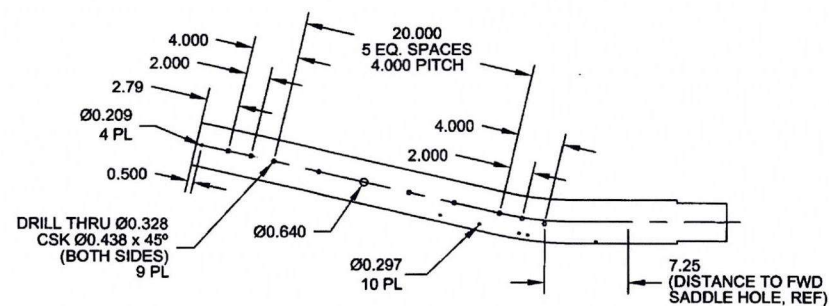
**D3391-011 FWD TUBE ASSEMBLY**  
ASSEMBLY DETAIL



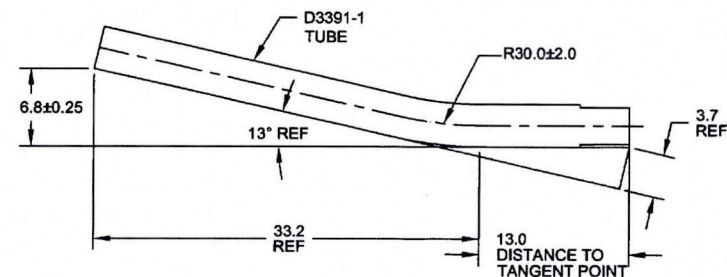
**DETAIL A**  
SCALE 2X

**D3391-011 FWD TUBE ASSEMBLY PARTS LIST**

| QTY<br>-011 | PART NUMBER   | DESCRIPTION       |
|-------------|---------------|-------------------|
| X           | D3391-011     | FWD TUBE ASSEMBLY |
| 1           | D3391-1       | TUBE              |
| 1           | D3401-041     | TOW CAP           |
| 9           | D3670-4200    | SPACER            |
| 4           | D3672-1       | WASHER            |
| 1           | D4095-051     | WEARSHOE          |
| 10          | AELS-1032-225 | INSERT            |
| 10          | AN3C4A        | BOLT              |
| 10          | NAS1149C0332R | WASHER            |



**D3391-011 DRILLING DETAIL**



**D3391-011 BENDING DETAIL**  
(MAKE FROM D3391-1)

**RELEASED**  
2016-04-28

|                                                                                                                                                                                                                                      |           |                                             |       |        |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|---------------------------------------------|-------|--------|
| DESIGN                                                                                                                                                                                                                               | PH        | <b>DART AEROSPACE USA, INC</b>              |       |        |
| DRAWN                                                                                                                                                                                                                                | ML        | EUGENE, OR                                  |       |        |
| CHECKED                                                                                                                                                                                                                              | CP        | DRAWING NO.                                 | REV.  |        |
| MFG. APPR.                                                                                                                                                                                                                           | <i>De</i> | D3391                                       | SHEET | 3 OF 1 |
| APPROVED                                                                                                                                                                                                                             | <i>CP</i> | TITLE                                       | SCALE |        |
| DE APPR.                                                                                                                                                                                                                             | <i>CP</i> | 412 FLOAT SKIDTUBE                          | NT    |        |
| DATE                                                                                                                                                                                                                                 | 16.01.14  | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |       |        |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |           |                                             |       |        |

INSTALL D3670-4200 SPACER  
SEAL WITH MAGNOBOND 6398  
GRIND FLUSH  
PRIOR TO PAINTING  
4 PL

# DETAIL B



INSTALL  
AELS-1032-225  
AFTER FINISH  
10 PL

D4095-051  
WEARSHOE

AN3C4A BOLT  
NAS1149C0332R WASHER  
6 PL

## D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH  
SIKAFLEX-241/-291



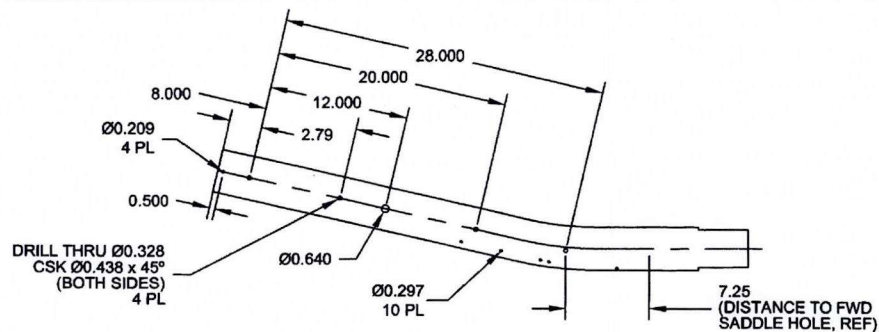
AN3C4A BOLT  
D3672-1 WASHER  
NAS1149C0332R WASHER  
4 PL

D3401-041  
TOW CAP

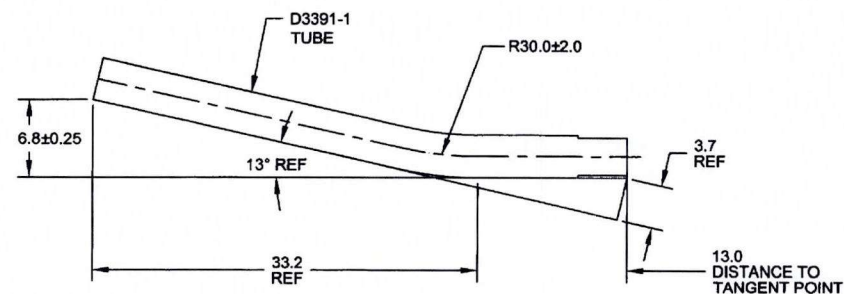
## DETAIL B SCALE 2X

### D3391-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY<br>-021 | PART NUMBER   | DESCRIPTION       |
|-------------|---------------|-------------------|
| X           | D3391-021     | FWD TUBE ASSEMBLY |
| 1           | D3391-1       | TUBE              |
| 1           | D3401-041     | TOW CAP           |
| 4           | D3670-4200    | SPACER            |
| 4           | D3672-1       | WASHER            |
| 1           | D4095-051     | WEARSHOE          |
| 10          | AELS-1032-225 | INSERT            |
| 10          | AN3C4A        | BOLT              |
| 10          | NAS1149C0332R | WASHER            |



### D3391-021 DRILLING DETAIL

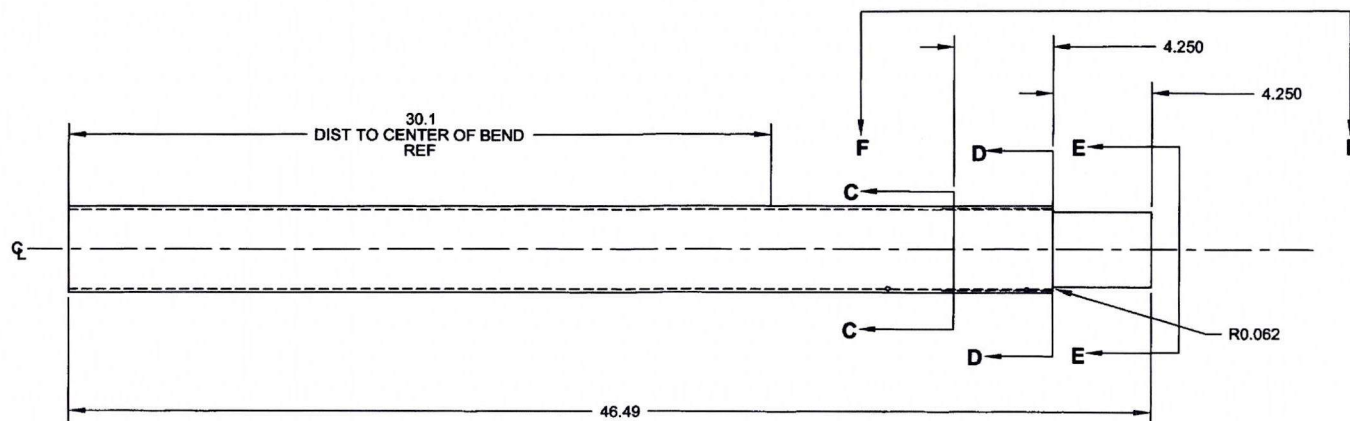


### D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

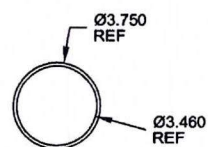
RELEASED  
2016-04-28

|            |                                                                                       |                                                                                                                                                                                                                                                                                    |               |
|------------|---------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PH                                                                                    | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                     |               |
| DRAWN      | ML                                                                                    | EUGENE, OR                                                                                                                                                                                                                                                                         |               |
| CHECKED    | CP                                                                                    | DRAWING NO.                                                                                                                                                                                                                                                                        | REV. J        |
| MFG. APPR. |  | D3391                                                                                                                                                                                                                                                                              | SHEET 4 OF 11 |
| APPROVED   |  | TITLE                                                                                                                                                                                                                                                                              | SCALE         |
| DE APPR.   |  | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                 | NTS           |
| DATE       | 16.01.14                                                                              | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |               |

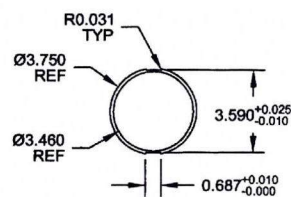




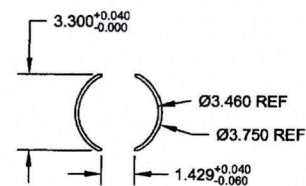
**D3391-1 TUBE**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



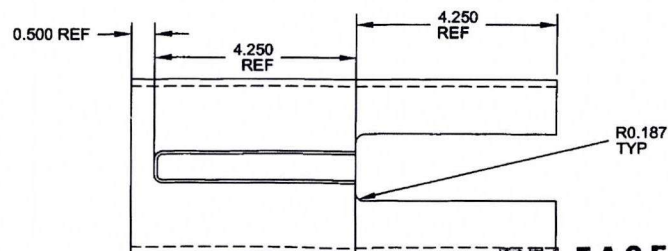
**SECTION C-C**



**SECTION D-D**



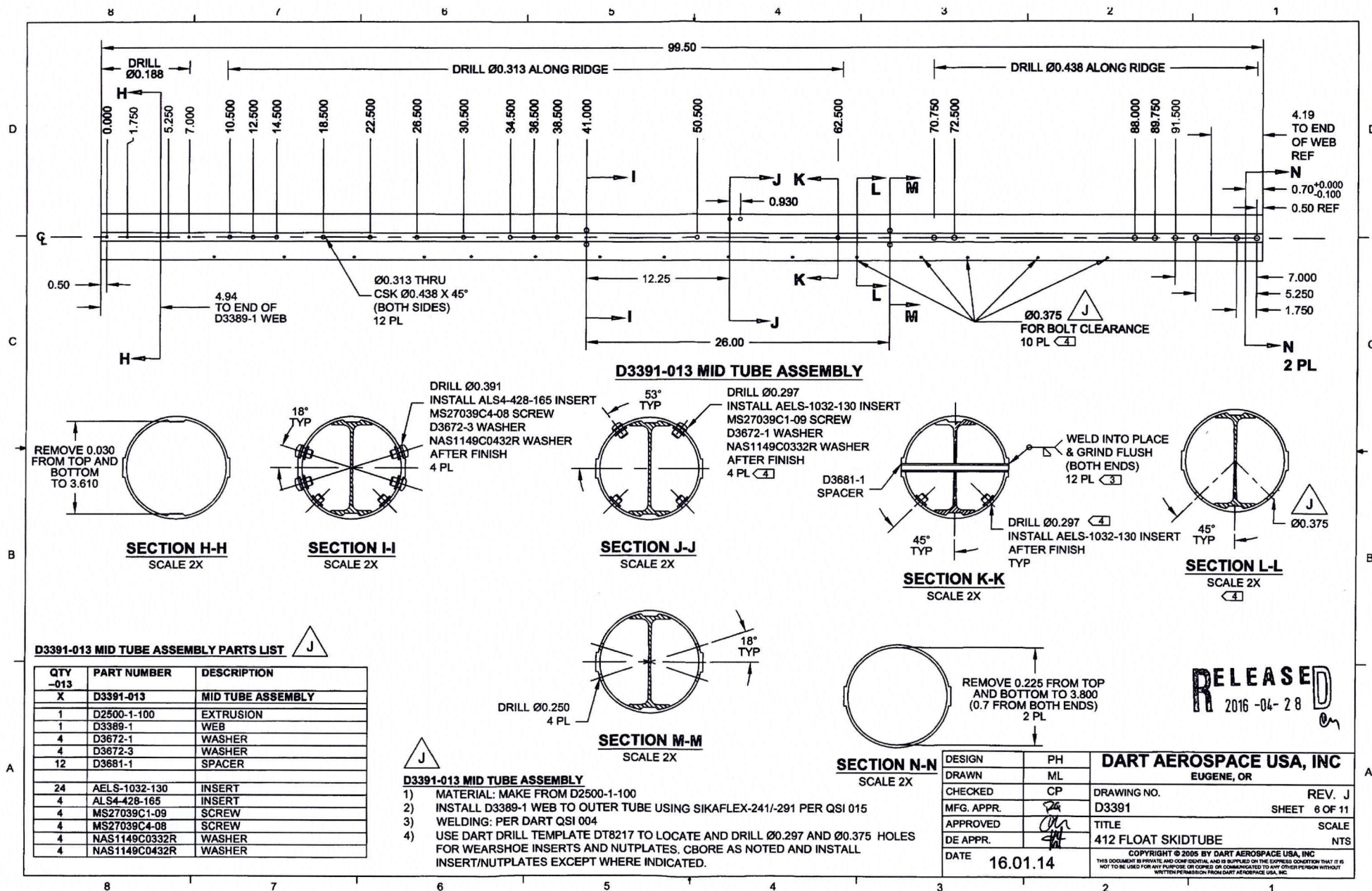
**SECTION E-E**



**VIEW F-F**  
SCALE 2X

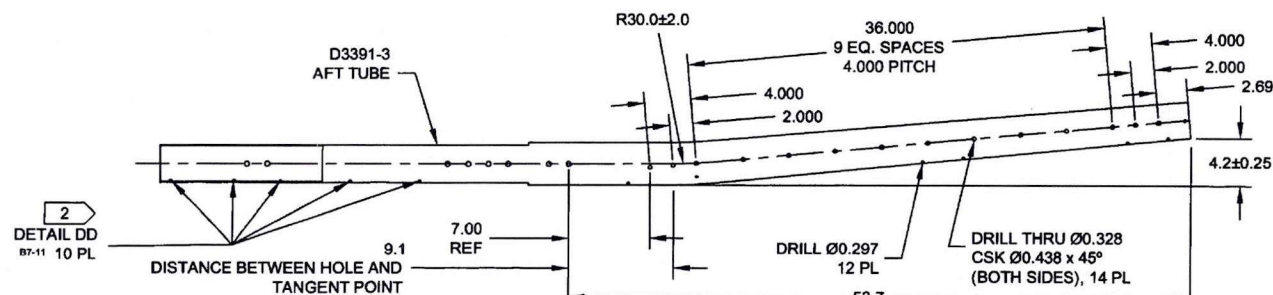
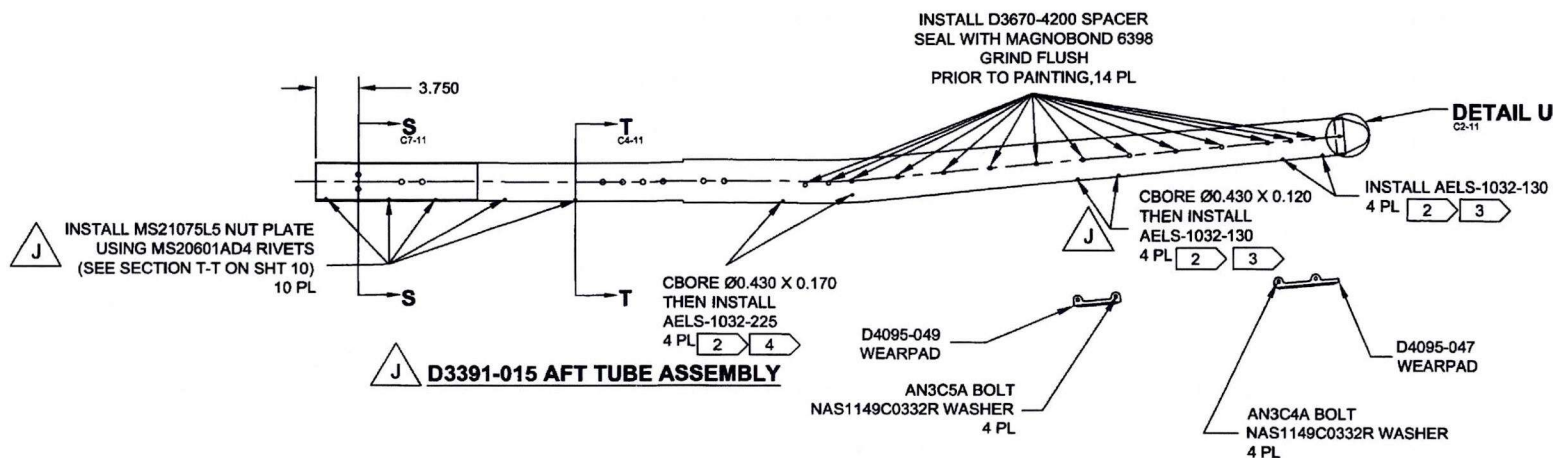
**RELEASED**  
2016-04-28

|            |          |                                                                                                                                                                                                                                                                                                             |               |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                                              |               |
| DRAWN      | ML       | EUGENE, OR                                                                                                                                                                                                                                                                                                  |               |
| CHECKED    | CP       | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. J        |
| MFG. APPR. | 22       | D3391                                                                                                                                                                                                                                                                                                       | SHEET 5 OF 11 |
| APPROVED   | 21       | TITLE                                                                                                                                                                                                                                                                                                       | SCALE         |
| DE APPR.   | 11       | 412 FLOAT SKIDTUBE                                                                                                                                                                                                                                                                                          | NTS           |
| DATE       | 16.01.14 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. HAS IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |               |









# D3391-015 AFT TUBE ASSEMBLY PARTS LIST

| QTY  | PART NUMBER   | DESCRIPTION         |
|------|---------------|---------------------|
| -015 |               |                     |
| X    | D3391-015     | AFT TUBE ASSEMBLY   |
| 1    | D2846         | AFT CAP             |
| 1    | D3391-3       | AFT TUBE            |
| 14   | D3670-4200    | SPACER              |
| 2    | D3672-1       | WASHER              |
| 1    | D4095-049     | WEARPAD             |
| 1    | D4095-047     | WEARPAD             |
| 8    | AELS-1032-130 | INSERT              |
| 4    | AELS-1032-225 | INSERT              |
| 4    | ALS4-428-165  | INSERT              |
| 6    | AN3C4A        | BOLT                |
| 4    | AN3C5A        | BOLT                |
| 20   | MS20601AD4    | RIVET, BLIND        |
| 10   | MS21075L5     | NUT PLATE, FLOATING |
| 10   | NAS1149C0332R | WASHER              |

## NOTES:

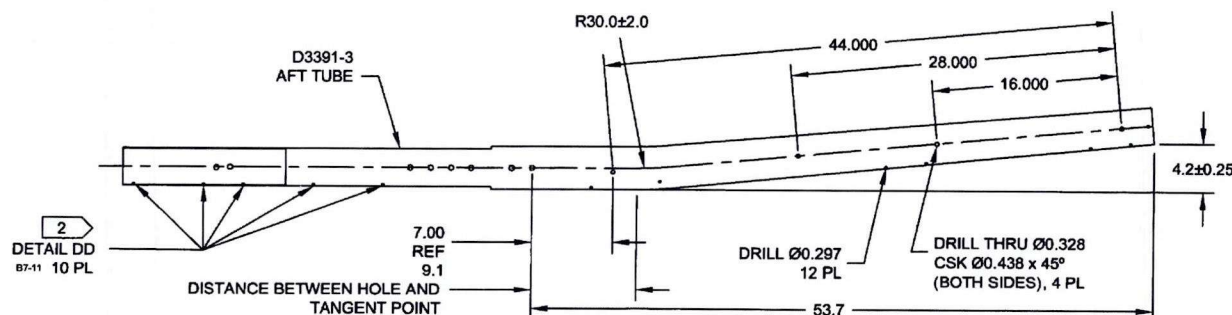
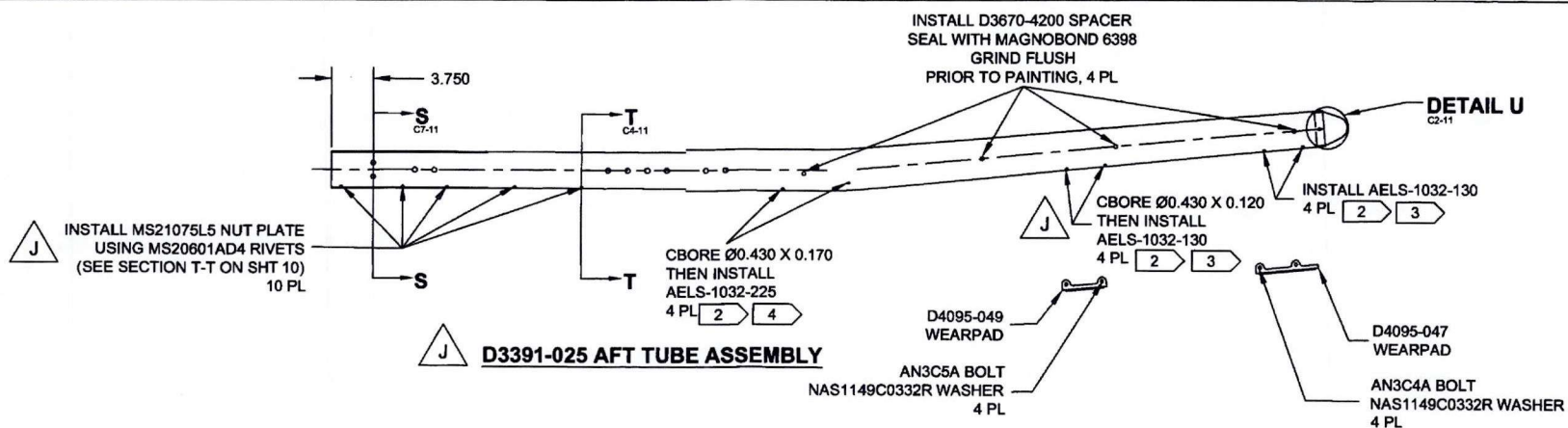
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

## BENDING AND DRILLING DETAIL

**RELEASED**  
2016-04-28

|                                                                                                                                                                                                                                     |                                                                                       |                                             |              |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------|--------------|
| DESIGN                                                                                                                                                                                                                              | PH                                                                                    | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN                                                                                                                                                                                                                               | ML                                                                                    | EUGENE, OR                                  |              |
| CHECKED                                                                                                                                                                                                                             | CP                                                                                    | DRAWING NO.                                 | REV.         |
| MFG. APPR.                                                                                                                                                                                                                          |  | D3391                                       | SHEET 8 OF 1 |
| APPROVED                                                                                                                                                                                                                            |  | TITLE                                       | SCALE        |
| DE APPR.                                                                                                                                                                                                                            |  | 412 FLOAT SKIDTUBE                          | NT           |
| DATE                                                                                                                                                                                                                                | 16.01.14                                                                              | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                                                                                       |                                             |              |





# D3391-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER   | DESCRIPTION        |
|-----|---------------|--------------------|
| 425 |               |                    |
| X   | D3391-025     | AFT TUBE ASSEMBLY  |
| 1   | D2646         | AFT CAP            |
| 1   | D3391-3       | AFT TUBE           |
| 4   | D3670-4200    | SPACER             |
| 2   | D3672-1       | WASHER             |
| 1   | D4095-049     | WEARPAD            |
| 1   | D4095-047     | WEARPAD            |
| 8   | AELS-1032-130 | INSERT             |
| 4   | AELS-1032-225 | INSERT             |
| 6   | AN3C4A        | BOLT               |
| 4   | AN3C5A        | BOLT               |
| 20  | MS20601AD4    | RIVET, BLIND       |
| 10  | MS21075L5     | NUT PLATE FLOATING |
| 10  | NAS1149C0332R | WASHER             |

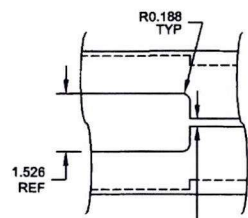
## NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

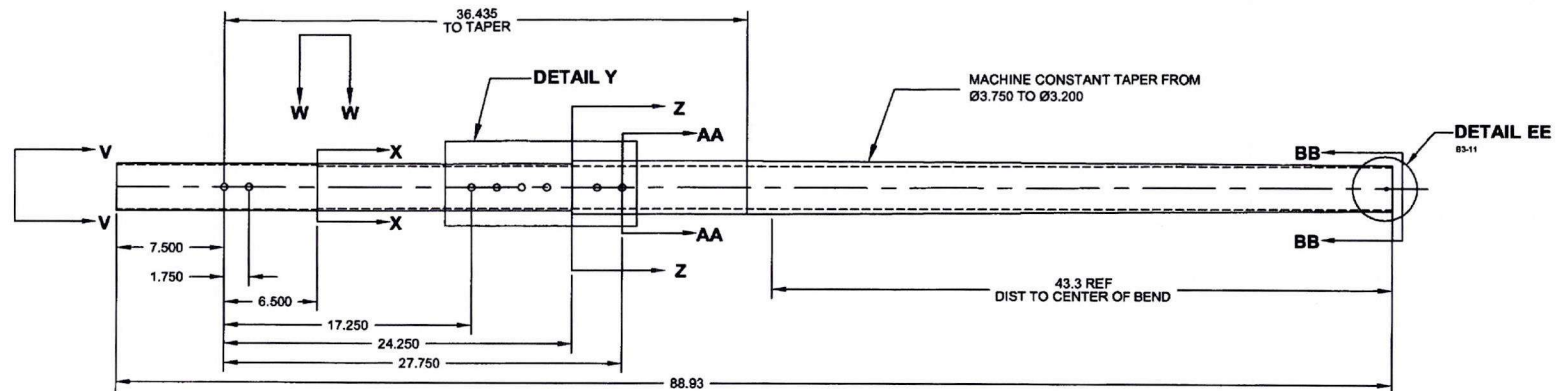
**RELEASED**  
2016-04-28

|                                                                                                                                                                                                                                     |                                                                                       |                                             |        |         |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------|--------|---------|
| DESIGN                                                                                                                                                                                                                              | PH                                                                                    | <b>DART AEROSPACE USA, INC</b>              |        |         |
| DRAWN                                                                                                                                                                                                                               | ML                                                                                    | EUGENE, OR                                  |        |         |
| CHECKED                                                                                                                                                                                                                             | CP                                                                                    | DRAWING NO.                                 | REV. J |         |
| MFG. APPR.                                                                                                                                                                                                                          |  | D3391                                       | SHEET  | 9 OF 11 |
| APPROVED                                                                                                                                                                                                                            |  | TITLE                                       | SCALE  |         |
| DE APPR.                                                                                                                                                                                                                            |  | AFT TUBE ASSEMBLY                           | NTS    |         |
| DATE                                                                                                                                                                                                                                | 16.01.14                                                                              | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |        |         |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                                                                                       |                                             |        |         |

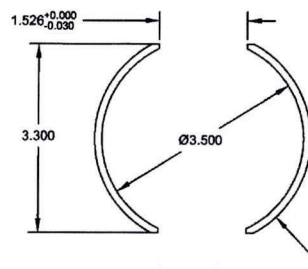
8 7 6 5 4 3 2 1



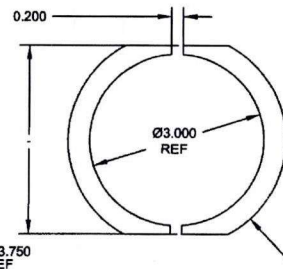
VIEW W-W  
SCALE 4X



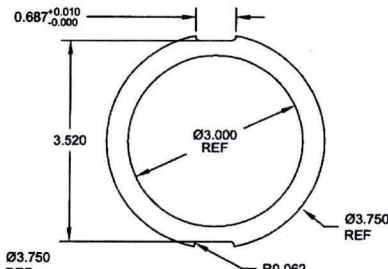
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090)



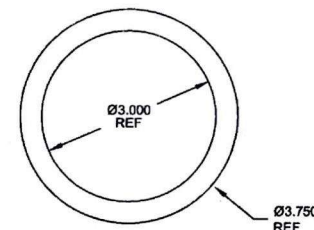
SECTION V-V  
SCALE 4X



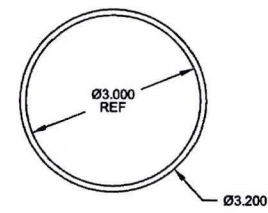
SECTION X-X  
SCALE 4X



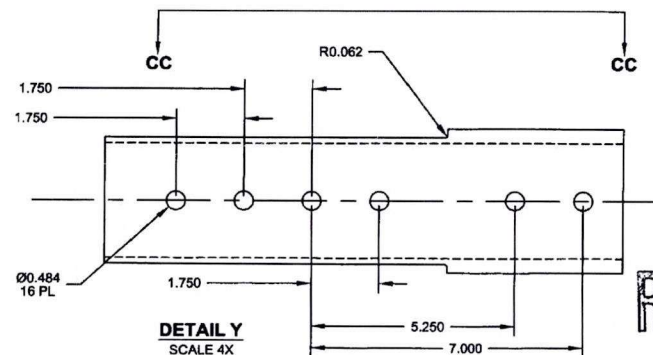
SECTION Z-Z  
SCALE 4X



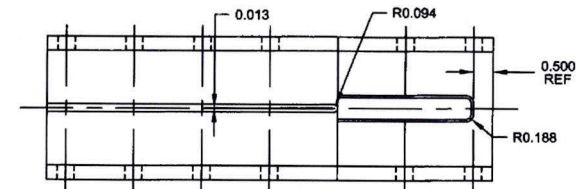
SECTION AA-AA  
SCALE 4X



SECTION BB-BB  
SCALE 4X



DETAIL Y  
SCALE 4X



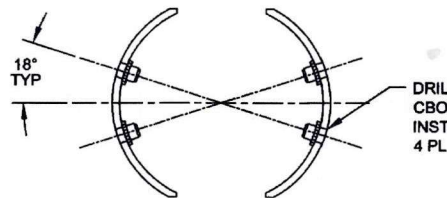
VIEW CC-CC

RELEASED  
2016-04-28

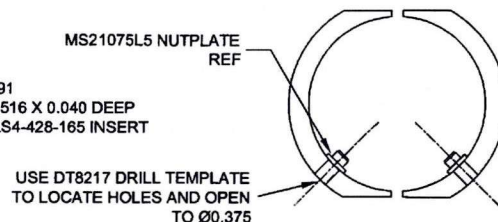
|                                                                                                                                                                                                                                     |                    |                                             |                |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|---------------------------------------------|----------------|
| DESIGN                                                                                                                                                                                                                              | PH                 | <b>DART AEROSPACE USA, INC</b>              |                |
| DRAWN                                                                                                                                                                                                                               | ML                 | EUGENE, OR                                  |                |
| CHECKED                                                                                                                                                                                                                             | CP                 | DRAWING NO.                                 | REV. J         |
| MFG. APPR.                                                                                                                                                                                                                          | <i>DEF</i>         | D3391                                       | SHEET 10 OF 11 |
| APPROVED                                                                                                                                                                                                                            | <i>CP</i>          | TITLE                                       | SCALE          |
| DE APPR.                                                                                                                                                                                                                            | <i>[Signature]</i> | 412 FLOAT SKIDTUBE                          | NTS            |
| DATE                                                                                                                                                                                                                                | 16.01.14           | COPYRIGHT © 2006 BY DART AEROSPACE USA, INC |                |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                    |                                             |                |

8 7 6 5 4 3 2 1

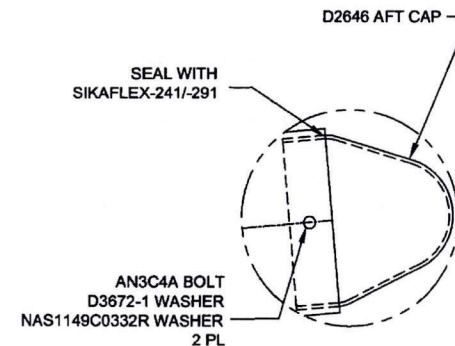




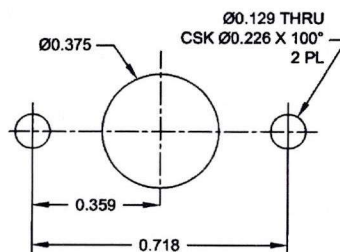
**SECTION S-S**  
SCALE 5X



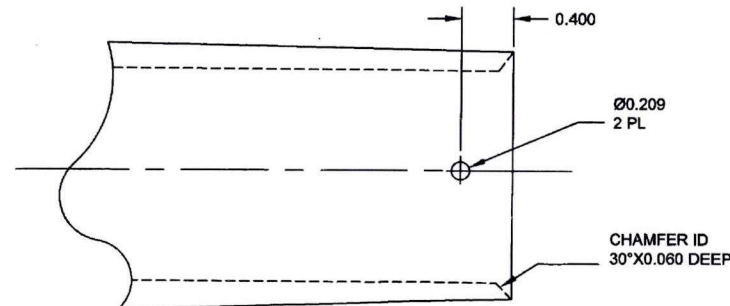
**SECTION T-T**  
SCALE 5X  
5 PL



**DETAIL U**  
SCALE 5X



**DRILLING DETAIL DD**  
SCALE 10X



**DETAIL EE**  
SCALE 2X

**NOTES:**  
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

RELEASED  
2016-04-28

|            |          |                                                                                                                                                                                                                                                                                    |                |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>                                                                                                                                                                                                                                                     |                |
| DRAWN      | ML       | EUGENE, OR                                                                                                                                                                                                                                                                         |                |
| CHECKED    | CP       | DRAWING NO.                                                                                                                                                                                                                                                                        | REV. J         |
| MFG. APPR. |          | D3391                                                                                                                                                                                                                                                                              | SHEET 11 OF 11 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                              | SCALE          |
| DE APPR.   |          | AFT TUBE ASSEMBLY                                                                                                                                                                                                                                                                  | NTS            |
| DATE       | 16.01.14 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                |